

Work Order ID 140804

140804

Page 1

Tuesday, January 19, 2016 10:32:05 AM

Item ID: D2600-3-130

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Extrusion Round 3" 350

Start Date: 1/19/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 2/1/2016 Req'd Qty: 50.00

50

Customer:

Reference: replacement for w/o138061

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2600

E

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 30249

a) Extrude as per Dwg D2600 (130" long)

b) Material: 6061-T6

c) Material certification is required.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DAS
13
9-89

JAN 19 2016

50

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.02

Packaging

Ensure material certification is attached

55x 8016-02-18

Work Order ID 140804

140804

Page 2

Tuesday, January 19, 2016 10:32:05 AM

Item ID: D2600-3-130 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Extrusion Round 3" 350
 Start Date: 1/19/2016 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 2/1/2016 Req'd Qty: 50.00 *50* Customer:
 Reference: replacement for w/o138061

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC18 In-Coming Inspection Material	0.00							
120									
QC	Memo	0.00							
Quality Control	Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester								
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01							
Packaging	LOCATION : LG002								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08							
Quality Control									

55 MAR 2 1 2016 DAS 13 9-89
 no good return for credit 55 pcs and replacement
 CL MAR 2 1 2016

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:



- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

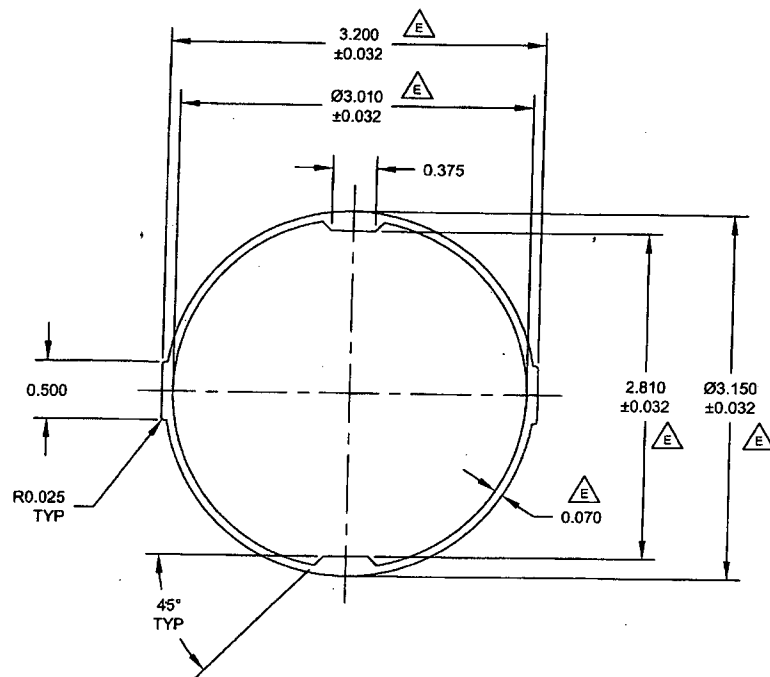
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

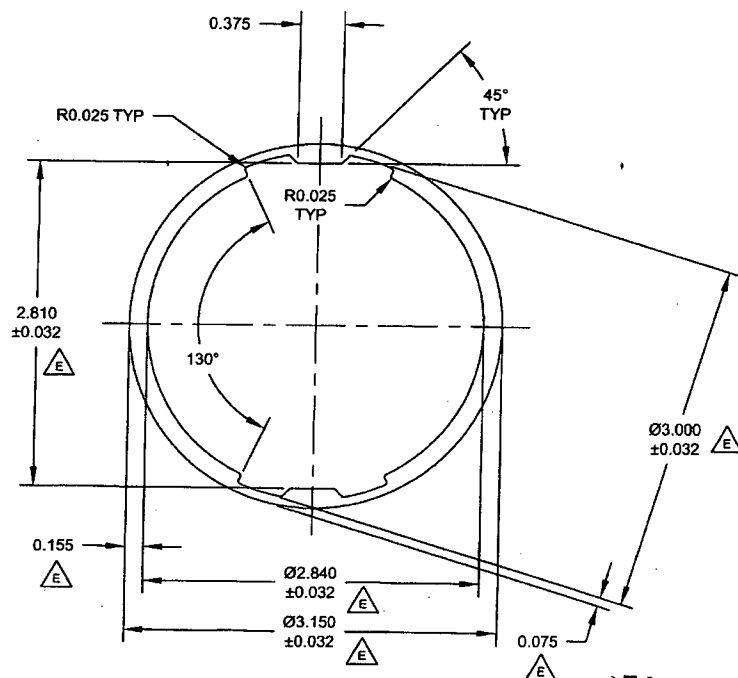
W040804

RELEASED
2012-01-11

E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>4</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>92</i>		
CHECKED	<i>AJS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BE</i>	D2600	SHEET 1 OF 3
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.	<i>#</i>	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D2600-1 EXTRUSION



D2600-3 EXTRUSION

RELEASED
2012-01-10

DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>4</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BE</i>	D2600	SHEET 2 OF 3
APPROVED	<i>11/10/18</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO30249

Purchase Order Date 10/23/2015

PO Print Date 1/19/2016

Page Number 1 of 1

Order From : VC-BON001
SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

E-MAILED
JAN 19 2016

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905-427-6550	Customer POID	
Vendor Fax	905-427-2246	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
		FOB	Destination-Collect
Ship Method	Yours ppd		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
3	D2600-3-130P	Extrusion Round 3" 350	2/3/2016 Yes 2/3/2016	50.00 Each	\$2,647.49
REPLACEMENT ORDER EXTRUDE AS PER DWG D2600-3-130 REV. E B140804 DIE # DDA-897122 LENGHT 130"					
EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENT					

Line Total: \$2,647.49

Outstanding PO Total: \$2,647.48

Change Nbr: 2

Change Date: 1/19/2016

Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100



signature
aluminum
CANADA INC.

1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

CO

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROS POUR TOUTE
CORRESPONDANCE

PACKING LIST DATE / DATE DU BODEAU
02-16-16

PACKING LIST NUMBER / N° DE BODEAU
024774

SALES ORDER NUMBER / N° DE COM
122107

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	8	042		R. BLAIS
JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE
		G.ATTENBOROU		M2A
CARRIER / TRANSPORTEUR				
CPU				

CUSTOMER ID / ID DU CLIENT	ORDER DATE / DE LA COM	CUSTOMER PO NUMBER / CLIENT PO Nombre
46024	01/19/16	PO30249 REPLACEMENT
		BILL OF LADING NUMBER / NO. DE CONNAISSEMENT
		024774

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	866 LB			DAA-897122-2	6061 T6		2	990	937 LB		
	393 KG			D2600-3-T30P	130.0000 IN			449	425 KG		
	50 PC				Cut(+): 0.0000 Cut(-): 0.0000	Min: -10 % Max: 10 %			55 PC		
						861236 / 294208	1	694	668		39 PC
						861236 / 294209	1	295	269		16 PC

Sp/6-02-18

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

2	990	937	LB
	449	425	KG
		55	PC
TOTALS			

2/16/2016

MATERIALS RETURN AUTHORIZATION

BILL OF LADING

SHIPPER:

DART AEROSPACE LTD.

DART AEROSPACE LTD
1270 Aberdeen St
Hawkesbury ON K6A 1K7
(613) 632-5200
CANADA

(TO CARRIER/SHIPPERS)

DATE: Tuesday, February 16, 2016

TIME: 12:23 PM

REFERENCE: 121005

SAC CAR: Melissa Alfaro

RMA Entered: Monday, January 18, 2016
4:08 PM

PROCESSING TIME
LAPSE (DAYS)

28.3

DETAILS:

PART#	PIECES	WEIGHT	UOM	RMA	CUSTOMER PART# OR DESCRIPTION
1 DAA-897122-2	50	866	LBS	20162217	D2600-3-130P ✓
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					
25					
26					
27					
TOTALS:	50	866			

COMMENTS: Maximum length of bundles, in feet: 0.00

CREDIT VALUE : \$ 2,647.49

Scrap value per Lb: \$ 1.007
Transport Cost per Lb: \$ 0.520

Return scrap value: \$ 871.63
Estimated freight cost: \$ 450.00

DISPOSITION:

PICK UP: YES
CREDIT: YES
SCRAP: YES
REPLACE: YES
REWORK: NO

QUALITY VALIDATED CLAIM?: YES
TO ST 25-3(Wednesday, February 10, 2016 6.0
LAPSE (DAYS) FROM 10 TO 40: 22.3
PRIMARY RC CODE: 302
ROOT CAUSE IDENTIFIED AT ST 30?: YES

ROOT CAUSE:

DIMENSIONS - OTHER

SPECIAL PICK UP INSTRUCTIONS: DELIVER LIVE-UNLOAD AT EXTRUSIONS SHIPPING

CARRIER: MCGILLION TRANSPORT

DELIVER TO: SIGNATURE ALUMINUM CANADA INC
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CANADA
ARRIVAL DATE:

SIGNATURE: _____

PICKUP DATE:



**signature
aluminum
CANADA INC**

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No.	Sales Order	Page
02/04/2016	5377204	122107	1
Cust PO	B/L No	Lot	Date
30249 REPLACEME	024774	861236	02/16/16

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897122-2	130" Mill 6061 T6	D2600-3-130P ✓
Gross Weight	990 LBS		
Net Qty	937 LBS		55 PCS 2 PKGS
Specification	AMS-QQ-A-200/8 & ASTM B221-08		Die Desc

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
<u>MPA / KSI</u>	<u>MPA / KSI</u>			
313.1 / 45.4	283.5 / 41.1	12.6	N/A	95

Salvage

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.69	0.19	0.23	0.05	0.89	0.06	0.15	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc



ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

2/16/2016

MATERIALS RETURN AUTHORIZATION

BILL OF LADING

SHIPPER:

DART AEROSPACE LTD.

DART AEROSPACE LTD

1270 Aberdeen St

Hawkesbury ON K6A 1K7

(613) 632-5200

CANADA

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14					
15					
16					
17					
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19					
20					
21					
22					
23					
24					
25					
26					
27					
TOTALS:	50	866			

COMMENTS: Maximum length of bundles, in feet: 0.00

CREDIT VALUE : \$ 2,647.49

Scrap value per Lb: \$ 1.007
Transport Cost per Lb: \$ 0.520Return scrap value: \$ 871.63
Estimated freight cost: \$ 450.00

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 CREDIT: YES
 SCRAP: YES
 REPLACE: YES
 REWORK: NO

QUALITY VALIDATED CLAIM?: YES

TO ST 25-3(Wednesday, February 10, 2016 6.0

LAPSE (DAYS) FROM 10 TO 40: 22.3

PRIMARY RC CODE: 302

ROOT CAUSE IDENTIFIED AT ST 30?: YES

ROOT CAUSE:

DIMENSIONS - OTHER

SPECIAL PICK UP INSTRUCTIONS: DELIVER LIVE-UNLOAD AT EXTRUSIONS SHIPPING

CARRIER: MCGILLION TRANSPORT

DELIVER TO: SIGNATURE ALUMINUM CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CANADA

SIGNATURE: _____

PICKUP DATE:

ARRIVAL DATE: